

Work Order ID 57872

Monday, April 19, 2010 3:31:32 PM



Page 1

Item ID: D205-778-011

Accept



Setup Start



Revision ID:

Item Name: Comfort Seat, LH/RH

Stop



Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 10/4/20 Tooling:

Date: _____

Run Start



QC:

Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9508

A

IIN D205-778

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D205-778-011 CHG 002

Scolos/05

3 L
PER 9CNU0570

HJ for LL 10/05/05

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

CL 4/5/3 CL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

S. 10/05/05

Memo

0.00



130



Packaging

Packaging

Packaging

0.00

0.00

Memo

Identify and pack for shipping as per PPP D205-778-101

Location: _____
PPP Rev: _____

10-5-5 SP

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/05/05

W 10/05/06

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Picklist Print

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Work Order ID: 57872

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC
per DSI 9508 DD 10.03-24 verified by:EC

IPP Rev:B as

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD6L Washer		Purchased	No			110	Each	1,169.000	16.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST347

1169

5519

1169

Purchased

No

110

Each

0.0000

8.0000

BSP-42

Rivet

D3752-1

Manufactured

No

110

Each

4.0000

1.0000

Seat Frame

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST252A

4

50655

4

Manufactured

No

110

Each

2.0000

1.0000

D3755-041

Seat Cushion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST252A

2

44543

2

5519

M114598

10.5.59

B58162

50655

50152

14/5/3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 4/26/2010

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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

* S D3756-041
Cushion
72

Manufactured No

110

Each

2.0000

1.0000



55153

[Signature]

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST252A

2

44544

2

110

Each

4.0000

2.0000



[Signature]

S D3758-041
Clamp
72

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST086

4

46658

4

110

Each

24.0000

2.0000



46658

[Signature]

S D3777-041
Clamp
72

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST087

24

46659

24

46659

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3800-3-200		Manufactured	No			110	f	188.0000	2.1053			
												
5 Hook and Loop Strip (2" Hard)												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST089

188

43367

113

56393

75

73367

1- Cut to length as per dwg

AN525-10R8

Purchased

No

110

Each

40.0000

8.0000

Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST325

40

111274

40

110

Each

72.0000

8.0000

111274

AN970-3

Purchased

No

Washers

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST349

72

113749

72

113749

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Shop Packet Print

Page 3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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IPP Rev:B as

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10 Washer		Purchased	No			110	Each	0.0000	8.0000			
MS21042L5 Nut		Purchased	No			100	Each	1,131.000	8.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

1131

113537

147

113644

984

MT13644

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Shop Packet Print

Page 4

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4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-778-011	13.0 lb	±22.0 in	±286 in-lb	47.0 in	611 in-lb
Comfort Seat Kit, LH / RH	5.9 kg	±0.56 m	±3.3 m-kg	1.19 m	7.0 m-kg

5.0 PARTS LIST

Qty	Part Number	Description
X	D205-778-011	COMFORT SEAT KIT (FITS LH & RH)
1	D3752-1	SEAT FRAME
1	D3755-041	CUSHION
1	D3756-041	CUSHION
2	D3758-041	CLAMP ASSEMBLY
*2	D3758-1	CLAMP
*2	D2182B028	RUBBER CUSHION
2	D3777-041	CLAMP ASSEMBLY
*2	D3777-1	CLAMP
*2	D2182B013	RUBBER CUSHION
4	D3800-3-200-060	HOOK STRIP
8	AN525-10R8	SCREW
8	AN670-3	WASHER
8	AN660JD10	WASHER
8	MS21042L3	NUT (OR MS21042-3)

* REFERENCE ONLY. PARTS ARE INCLUDED IN ASSEMBLY ABOVE.

W/O:		WORK ORDER CHANGES					
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-778 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-778 REV. 1

REF TCCA STC: SH08-37
REF FAA STC: SR02704NY
REF EASA STC: EASA.IM.R.S.01518

PURPOSE:

To provide instructions to allow the hook strip (ie. velcro) on the D3752-1 Seat Frame to be fastened with rivets.

CHANGE:

D205-778-011 Comfort Seat Kits at CHG 002 have rivets and washers that may be installed to fully secure the D3800-3-200-060 Hook Strip to the D3752-1 Seat Frame. The parts list of Installation Instructions IIN-D205-778 and Instructions for Continued Airworthiness ICA-D205-778 is amended as shown below. Installation of the rivets is optional.

PARTS LIST

QTY	Part Number	Description
-011		
X	D205-778-011	Comfort Seat Kit
8	BSP-42	Rivet (Add)
16	NAS1149DN616J	Washer (or AN960JD6L) (Add)

INSTALLATION INSTRUCTIONS

Install the BSP-42 rivets as detailed below, see Figure 1 of this service instruction as reference:

- 1) Ensure location of D3800-3-200-060 Hook Strip lines up with loop strip on seat cushions.
- 2) Drill D3752-1 Seat Frame using 9/64" (Ø0.141) drill in appropriate locations: ensure rivet location will not interfere (contact) with the OEM metal seat frame. Deburr hole.
- 3) Install each BSP-42 rivet with qty(2) NAS1149DN616J washers (one on either side of the plastic seat frame). It is acceptable to substitute longer/shorter BSP rivets or thicker NAS1149DN632J washers to ensure proper fit.

UPGRADE KIT

For D205-778-011 Comfort Seat Kits at CHG 001, the DSI-9508-011 Rivet Kit is available from Dart:

QTY	Part Number	Description
-011		
X	DSI-9508-011	Rivet Kit
8	BSP-42	Rivet
16	NAS1149DN616J	Washer (or AN960JD6L)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAG # 01-0-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.03.02
CERT. NO.: SH08-37
ISSUE NO.:

A	NEW ISSUE	CP	10.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>92</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>92</i>		
CHECKED	<i>13</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9508	SHEET 1 OF 2
APPROVED	<i>14</i>	TITLE	SCALE
DE APPR.	<i>14</i>	RIVET KIT	NTS
DATE	10.03.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
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